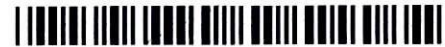




Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D2857-1**  
**Job Sheet 175005**



Part No: D2857-1

Job Qty: 20 ea

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/26/18

Job Tracking No:

Due Date: 4/2/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |                  | Sign-off            |
|-------|------------------------|--------|------------|----------|-----------|---------|-----------------------|------------------|---------------------|
|       |                        |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time        |                     |
| 90    | Start up Operation     | 20 Ea  |            | 3/30/18  | 0.00      | 0.00    | Start Up Machining-1  | 1                | 1/18 2018/3/29      |
| 100   | Bandsaw                | 20 pcs |            | 3/30/18  | 0.00      | 0.69    | Bandsaw1              |                  | 1/18 2018/3/29      |
| 110   | CNC Vertical Machining | 20 pcs |            | 3/31/18  | 0.13      | 11.07   | HAAS1-2               |                  | 5/8/18 A.A 18-03-29 |
| 130   | QC                     | 20 pcs |            | 3/31/18  | 0.00      | 0.00    | QC8 Machining-1       |                  | 2/15/18 X 18-04-02  |
| 140   | HandFinish             | 20 pcs |            | 3/31/18  | 0.00      | 0.44    | HandFinish1           |                  | SA 18-04-02         |
| 160   | Powdercoat             | 20 pcs |            | 4/2/18   | 0.00      | 0.30    | Powdercoat1           |                  | BL 18-4-2           |
| 170   | QC                     | 20 pcs |            | 4/2/18   | 0.00      | 0.00    | QC3                   |                  | 2/15/18 04          |
| 180   | Packaging              | 20 pcs |            | 4/2/18   | 0.00      | 0.00    | Packaging3-1          | Stop APR 03 2018 | APR 03 2018         |
| 190   | QC21-SA                | 20 Ea  |            | 4/2/18   | 0.00      | 0.00    | QC21                  |                  | APR 03 2018         |

Part Op 100 - Cut blanks 4.425"

Descriptions: 110 - 1-Machine per folio FA940 DWG REV: 2-Deburr any rough edges

160 - START TIME: 1:20 FINISH TIME: 1:55 - 20.1.300° 11/13/18

### Job BOM

| Part / Item          | Component Name          | Quantity           | Operation             | Container |
|----------------------|-------------------------|--------------------|-----------------------|-----------|
| M6061T6B2.000X01.250 | 6061-T6 Bar 2.00 X 1.25 | 7.4000 ft (.37 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part       | Required | Inventory | Allocated |
|-----------------------|----------------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6B2.000X01.250 | 7        | 28        | 0         |



Container No: S056866



Part: D2857-1

Job No: 175005

Serial No/Batch: S056866

Revision:

Inspector:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 03/29/18

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| Part Specifications |               |                                |                |       |                  |
|---------------------|---------------|--------------------------------|----------------|-------|------------------|
| Spec No             | Description   | Target/Tolerance               | Limits         | Type  | Special Comments |
| 1                   | Hinge Bracket | 4.300inches ± 0.010            | 4.310<br>4.290 | 4,301 |                  |
| 2                   | Hinge Bracket | 4.000inches ± 0.010            | 4.010<br>3.990 | 4,000 |                  |
| 3                   | Hinge Bracket | 0.340inches ± 0.010            | 0.350<br>0.330 | ,340  |                  |
| 4                   | Hinge Bracket | 1.110inches ± 0.005            | 1.115<br>1.105 | ,111  |                  |
| 5                   | Hinge Bracket | 1.790inches ± 0.010            | 1.800<br>1.780 | ,1790 |                  |
| 6                   | Hinge Bracket | 1.320inches ± 0.005            | 1.325<br>1.315 | ,1321 |                  |
| 7                   | Hinge Bracket | 2.000inches ± 0.010            | 2.010<br>1.990 | 2,000 |                  |
| 8                   | Hinge Bracket | 0.340inches ± 0.010            | 0.350<br>0.330 | ,339  |                  |
| 9                   | Hinge Bracket | 0.447inches ± 0.010            | 0.457<br>0.437 | ,447  |                  |
| 10                  | Hinge Bracket | 0.171inches + 0.005<br>- 0.000 | 0.176<br>0.171 | ,172  |                  |
| 11                  | Hinge Bracket | 0.147inches ± 0.010            | 0.157<br>0.137 | ,148  |                  |
| 12                  | Hinge Bracket | 0.376inches ± 0.010            | 0.386<br>0.366 | ,376  |                  |
| 13                  | Hinge Bracket | 0.126inches ± 0.010            | 0.136<br>0.116 | ,120  |                  |
| 14                  | Hinge Bracket | 0.063inches ± 0.010            | 0.073<br>0.053 | ,057  |                  |
| 15                  | Hinge Bracket | 0.166inches + 0.005<br>- 0.000 | 0.171<br>0.166 | ,168  |                  |
| 16                  | Hinge Bracket | 0.911inches ± 0.010            | 0.921<br>0.901 | ,909  |                  |
| 17                  | Hinge Bracket | 0.600inches ± 0.010            | 0.610<br>0.590 | ,598  |                  |
| 18                  | Hinge Bracket | 0.125inches ± 0.010            | 0.135<br>0.115 | ,125  |                  |
| 19                  | Hinge Bracket | 0.150inches ± 0.010            | 0.160<br>0.140 | ,150  |                  |

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SBL 18/03/28